In Fig. 15, for instance, is shown a box jig which looks like a typical open jig. The jig body *A* is made in one solid piece, cored out as shown, in order to make it lighter. The piece to be drilled, *B,* shown inserted in the jig, has all its holes drilled in this jig, the holes being the screw holes C, the dowel pin holes D, and the large bearing hole *E.* The bosses of the three screw holes *C* are also faced on the top, and the bearing is faced on both sides while the work is held in the jig. The work is located against two dowel pins driven into the holes *F,* and against two lugs at G, not visible in the illustration, located on either side of the

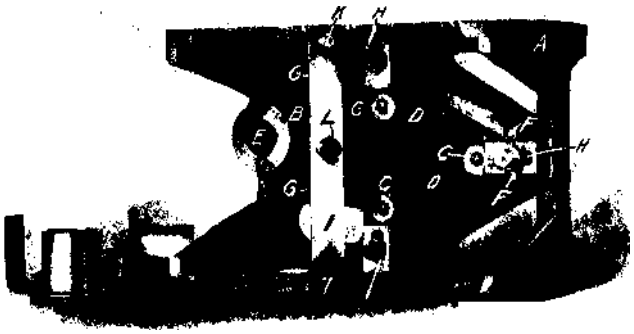

Fig. 15. Box Jig which Resembles the Open Type

work. In these lugs are placed set-screws or adjustable sliding points. It may seem incorrect not to locate the bracket in regard to the hole *E* for the bearing, so as to be sure to bring the hole concentric with the outside of the boss. This ordinarily is a good rule to follow, but in this particular case it is essential that the screw holes be placed in a certain relation to the outline of the bracket in order to permit this to match up with the pad on the machine on which the bracket is used. Brackets of this shape may be cast very uniformly, so that locating them in the manner described will not seriously interfere with drilling the hole *E* approximately in the center of its boss. The work is firmly held in the jig by the three straps *H,* care being taken in designing the jig that these straps are placed so they will not interfere with the facing tools.